

Work Order ID 71719

Thursday, July 07, 2011 1:01:13 PM



Page 1

Item ID: D3296-1

Accept



Setup Start



Revision ID:

Item Name: Door Panel

Stop



Start Date: 7/7/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 11/07/07 Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3296	Rev A

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

2024 . 063

Memo

1-Cut as per Dwg D3296 Dwg Rev: A Prog Rev: A 2-

Deburr if necessary

10/08/11

10

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

10/08/11

10

120



QC8- Inspect parts - second check

QC

Quality Control

Sulostir

(H6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71719

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Page 2

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Start Date: 7/7/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Small Fab

Small Fab

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Small Fab

Small Fab

0.00

n/a

~~10 of 10 100% 100%~~

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

10 of 10 100%

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

~~100% 100% 100% 100%~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

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Setup Start



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Item Name: Door Panel

Stop



Start Date: 7/7/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionIdentify as per dwg & Stock Location: 186

Packaging

Packaging

160



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

11/8/17

SD 10x

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

11/8/18

11/8/18

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, July 07, 2011 1:01:10 PM

Work Order ID: 71719



Parent Item: D3296-1



Parent Item Name: Door Panel

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP C□05.10.14□Added step 14□KJ/EC□
IPP Rev:D Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	250.3800	0.6596	6.943158			

2024-T3 .063 sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT022	250.38	
117018	25.88	
117392	224.5	

7.0 80 11/08/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	71719
Description: Door Panel	Part Number:	D3296-1
Inspection Dwg: D3296	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11/08/11	Date:	06/06/12	Date:	N/A

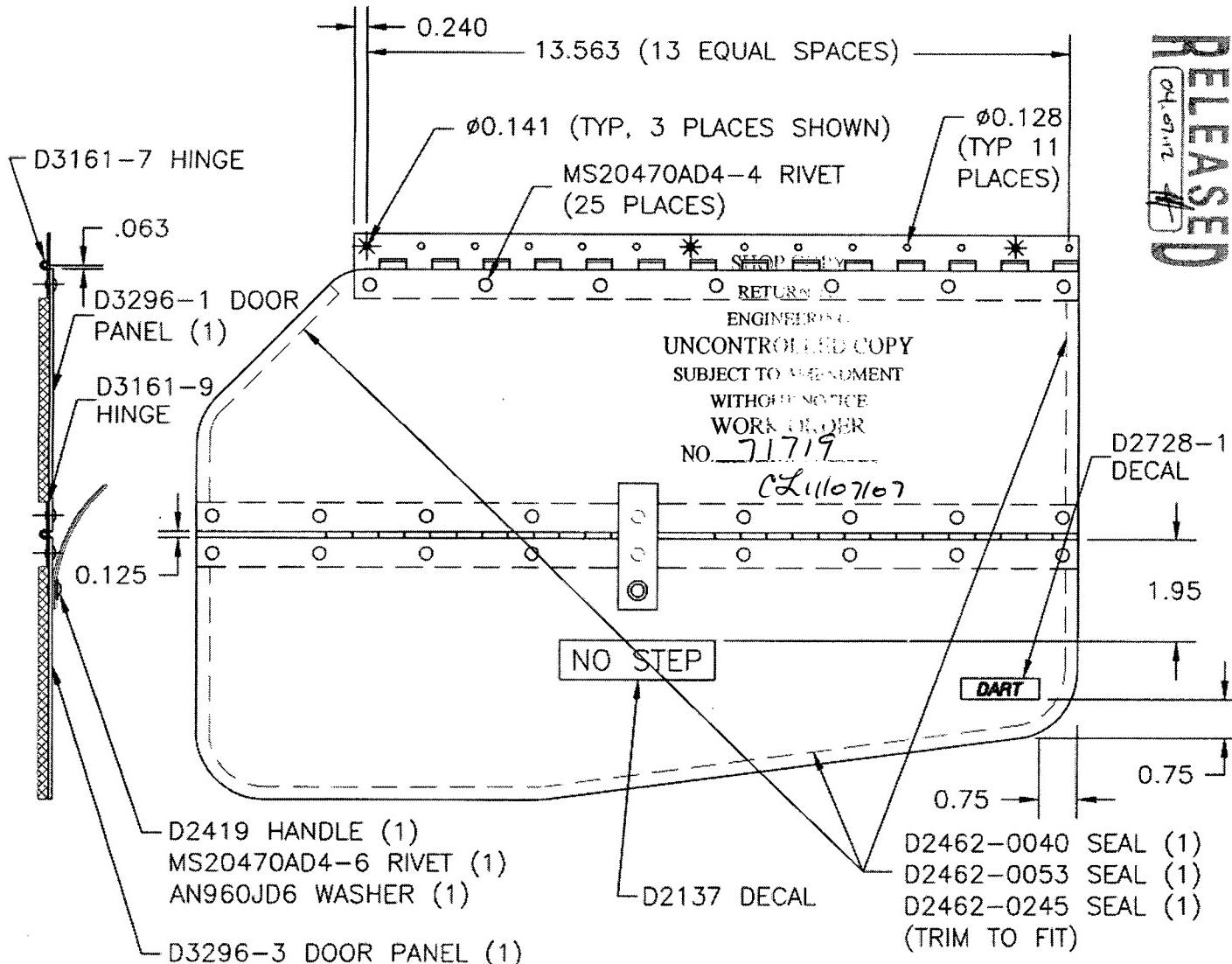
Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue P/O D3296-041	KJ/JLM	JG

RELEASED
04.07.07

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
<i>IP</i>	<i>IP</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	REV. A
		1 OF 2
DATE 04.06.28	TITLE DOOR ASSEMBLY	SCALE 1:3
A	04.06.28	NEW ISSUE



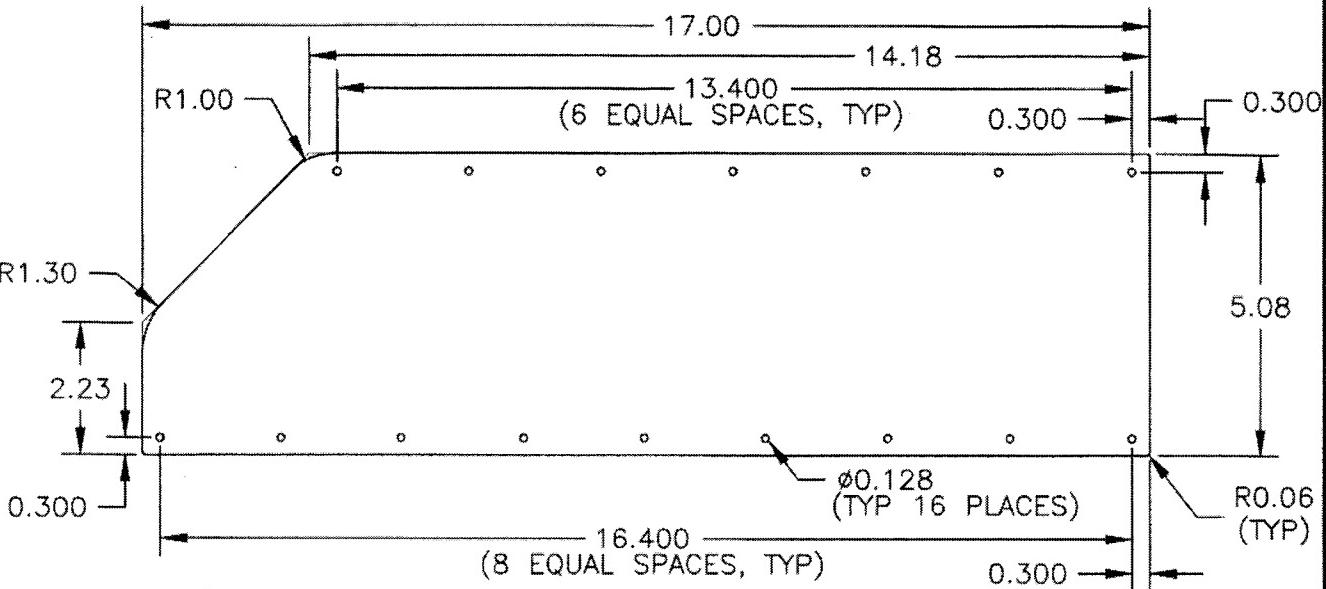
D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

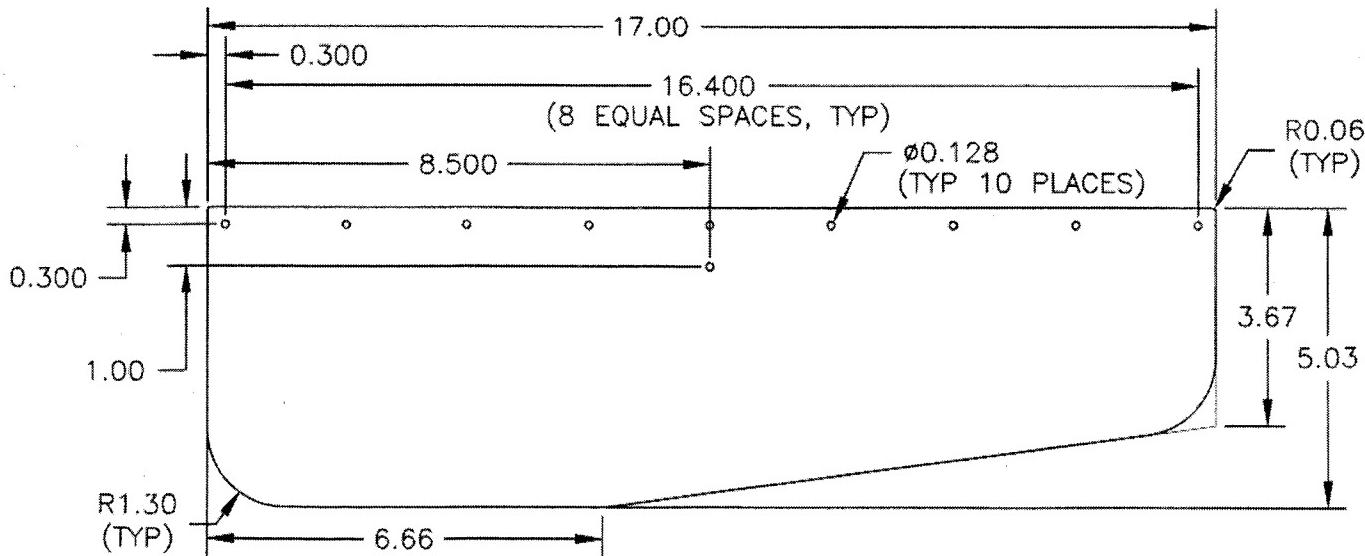


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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3296	2 OF 2
DATE	TITLE	SCALE	
04.06.28	DOOR ASSEMBLY	1:3	



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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